

Work Order ID 144878

April 26, 2016 1:39:17 PM

144878

Page 1

Item ID: D4785-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Base Assembly, LH/RH
Start Date: 6/3/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: SA Date: 20160426 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4785	B								

100

Weld per dwg A/R S.S. rod Batch: B133750 0.00

Large Fab

100

Large Fab

Large Fab

Memo

3.12

1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785

inspect before welding mesh

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

3- weld hinge (3) and Mounting brackets as per dwg D4785

take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

ENSURE BOTTOM OF BASE RIB ARE STRAIGHT

1x CC 16-5-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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of 1

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 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 6/3/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
110									
QC	Memo	0.00							
Quality Control	***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding								
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.02							
Quality Control	***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding								
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	1.07							
Hand Finishing									

① 16-05-27

① 16-05-27

1 ① 16-05-30, 8:38

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>M 134631.</i>								
Powdercoat	Memo	0.66							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT: <i>9:40.</i>								
	START TIME: <i>9:40.</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>D.D.</i>								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.01							
Quality Control									

1 0 16-05-30 253

1A 0 16/05/30

DA
15
9-80

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.41							
Hand Finishing	✓ Pick kit and assemble								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.02							
Quality Control									
170	Identify as per dwg & Stock Location: <u>w/b</u>	0.00							
170									
Packaging	Memo	0.01							
Packaging									

D 4784-011 / B144878 1x f ll 6/6/16

DAS
38
9-89
JUN 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

MCS JUN 03 2016
Lm 16/06/03

DQA: _____ Date: _____



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							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : ☐																									

Picklist Print

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Page 1

Work Order ID: 144878

144878

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:C
13.07.04 revise bom per dwg rev.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4785-1		Manufactured	No			100	Each	4.0000	2	2			
/ *D4785-1*									**			CC 16-5-26	
Rib													
					<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>				
					WA004	4		B144940	→	(2x)			
					133295	4							
D4785-5		Manufactured	No			100	Each	9.0000	3	3			
/ *D4785-5*									**			CC 16-5-26	
Rib													
					<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>				
					WA004	9		B144242	→	(3x)			
					121284	3							
					133297	6							
D4785-115		Manufactured	No			100	Each	0.0000	4	4			
/ *D4785-115*												CC 16-5-28	
Rib Assembly													
D4785-117		Manufactured	No			100	Each	0.0000	2	2			
/ *D4785-117*												CC 16-5-26	
Rib Assembly													
D4785-3		Manufactured	No			100	Each	4.0000	2	2			
/ *D4785-3*									**			CC 16-5-26	
Rib													
					<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>				
					WA004	4		B144941	→	(2x)			
					133300	4							

Picklist Print

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Page 2

Work Order ID: 144878

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

144878

D4785-041

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

63.0000

3

3

D4017-7

Rib

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

63

141853

60

142415

3

34

D4034-041

Manufactured No

100

Each

3.0000

1

1

D4034-041

Aft Upper Rib Assembly

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

3

B146367

142374

3

1x

D4034-043

Manufactured No

100

Each

3.0000

1

1

D4034-043

Fwd Upper Rib Assembly

B146350 1x

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

3

142375

3

D3916-5

Manufactured No

100

Each

0.0000

2

2

D3916-5

Light Rib

B144463 1x

CC 16-5-26

D3913-1

Manufactured No

100

Each

1.0000

1

1

D3913-1

Rib

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

1

B144850

141916

1

1x

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Page 3

Work Order ID: 144878

144878

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D3913-3

Manufactured No

100 Each 1.0000 1 1

D3913-3

Rib

**

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

1 B144851 → (1x)

141917

1

D3913-9

Manufactured No

100 Each 1.0000 1 1

D3913-9

Hinge Rib

**

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

1 B144852 → (1x)

141425

1

D4793-1

Manufactured No

100 Each 3.0000 3 3

D4793-1

Handle Plate

**

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

3 B144255 → (3x)
3 B144943

119401

3

D4793-3

Manufactured No

100 Each 0.0000 1 1

D4793-3

Handle Plate, Wide

**

CC 16-5-26

D4672-1

Manufactured No

150 Each 21.0000 2 2

D4672-1

Blanking Plate

**

CC 16-5-26

Location

Loc Qty

Loc Code

WA004

21

141229

21

(2x)

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Page 4

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Work Order ID: 144878

144878

D4785-041

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

100 Each 40.0000 2 2

D4021-5

Blanking Plate

Location	Loc Qty	Loc Code
ST071	40	
137592	5	
142656	34	
1774896k	1	

**

8808

MAY 30 2016

M304EX0.75-16F Purchased No

100 sf 975.0000 33 33

M304EX0 75-16F

Expanded Metal Flat SS

Location	Loc Qty	Loc Code
WA004	975	
M133868	25	
M134184	77	
M134331	233	
M134643	640	

**

CC 16-5-26

D4020-11 Manufactured No

100 Each 29.0000 2 2

D4020-11

End Mesh, Basket

Location	Loc Qty	Loc Code
WA004	29	
139947	2	
142361	27	

**

CC 16-5-26

D4016-1 Manufactured No

100 Each 27.0000 3 3

D4016-1

Hinge Half, Base

Location	Loc Qty	Loc Code
WA004	27	
140745	27	

**

CC 16-5-26

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Page 5

Work Order ID: 144878

144878

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D2931

Manufactured No

150 Each

1,593.000 2

D2931

Bumper

**

2

DAS
6-6-89
MAY 30 2016

Location

Loc Qty

Loc Code

ST013

70

86435

70

ST025A

1523

86435

1523

D2581

Manufactured No

100 Each

76.0000 2

D2581

Mounting Bracket

**

2

11-16-5-26

Location

Loc Qty

Loc Code

WA004

76

132771

1

136270

2

139082

5

141097

20

142787

48

AN3-10A

Purchased No

150 Each

227.0000 6

AN3-10A

Bolt

**

2

134754

DAS
6-6-89
MAY 30 2016

Location

Loc Qty

Loc Code

GA

41

m132763

1

m134573

40

over003

100

m134249

100

ST349

86

m133992

27

m134573

59

Picklist Print

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Page 6

Work Order ID: 144878

144878

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

398.0000

2

2

MS20600-AD4W3

Cherry Rivets

Location

Loc Qty

Loc Code

GA

160

m129795

160

ST308

154

m133316

24

m134167

130

WA003

84

m130018

84

2

9-59 D45

MS21042L3

Purchased

No

150

Each

2,081.000

6

6

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

761

m133790

3

m134360

758

ST303

1220

m134039

12

m134360

608

m134634

600

9-59 D45

NAS1149DN832J

Purchased

No

150

Each

1,439.000

2

2

NAS1149DN832J

Washer

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST265

1355

M134180

1355

2

9-59 D45
MAY 30 2016

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Page 7

Work Order ID: 144878

144878

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

1,715.000

12

12

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1403

m134257

1403

MAY 30 2016
8:00 DAS

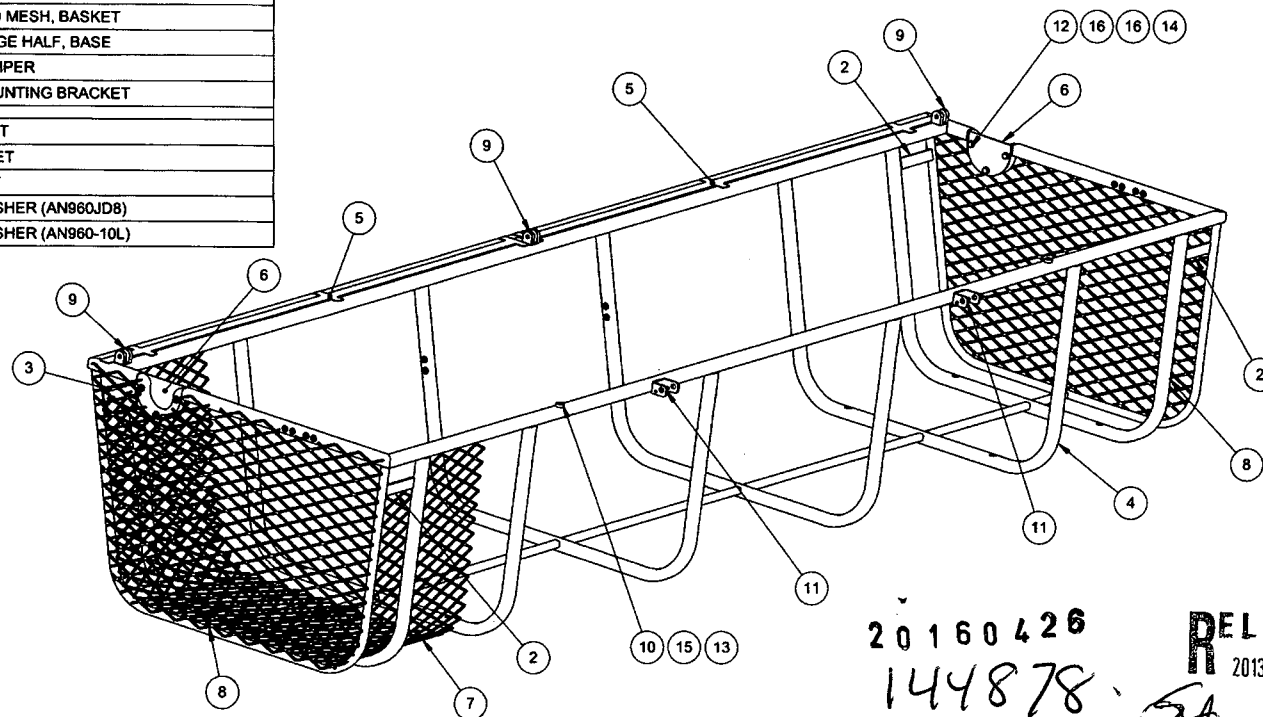
12

April 26, 2016 1:39:21 PM

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Page 7

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20800AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



D4785-041 LONG BASKET BASE ASSY, LH/RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

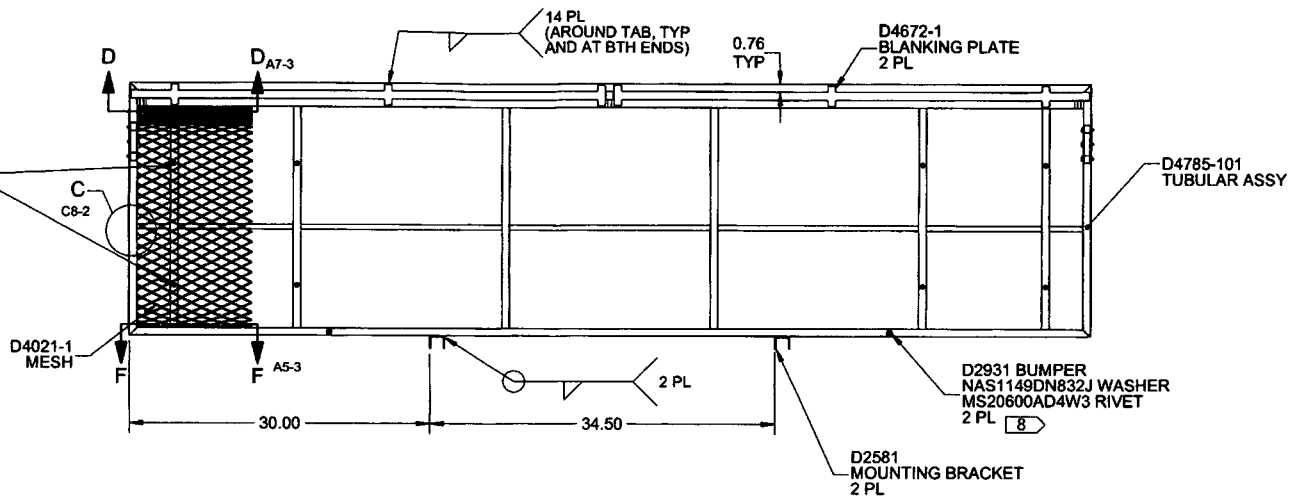
20160426
144878

RELEASED
2013-06-20

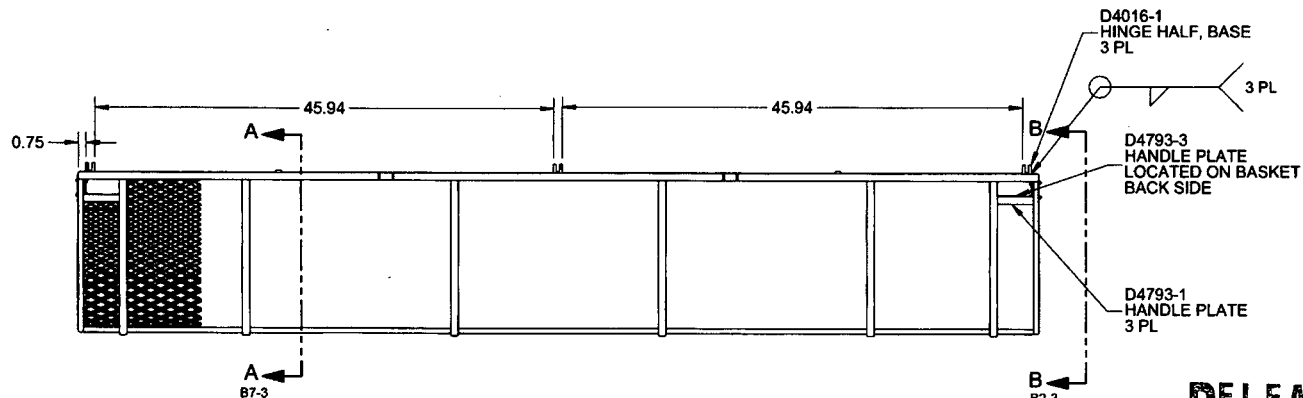
B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	REV. B	
CHECKED	DC	SHEET 1 OF 7	
MFG. APPR.	DS	D4785	
APPROVED	DS	TITLE	
DE APPR.	DS	LONG BASKET BASE ASSY	
DATE	13.06.11	SCALE	
		NTS	

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP



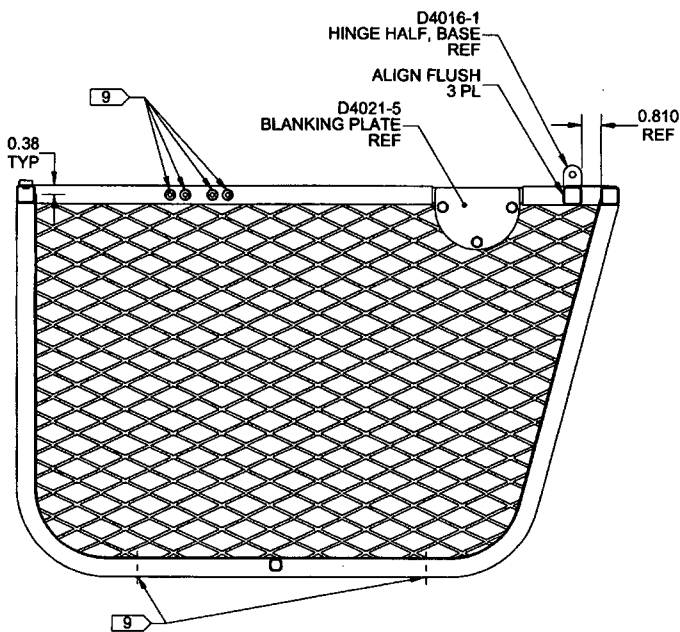
DETAIL C D7-2



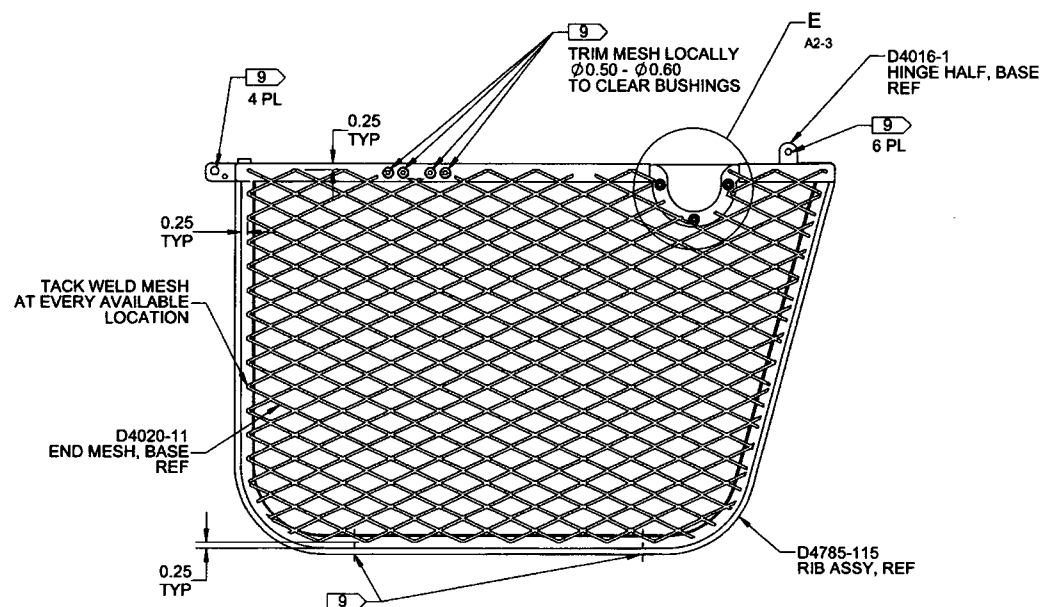
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-06-20

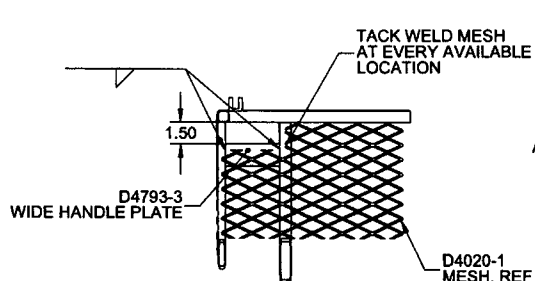
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>KS</i>	D4785	SHEET 2 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



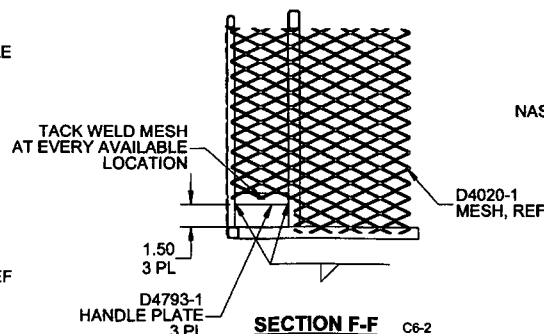
SECTION A-A B7-2



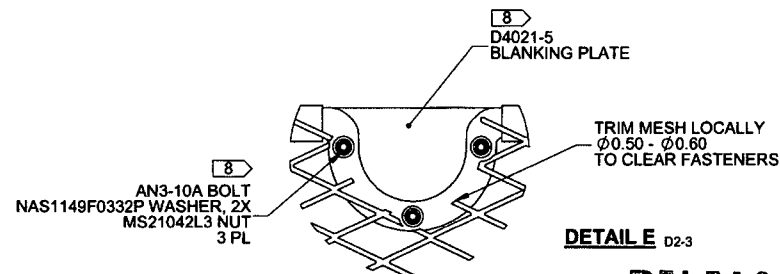
SECTION VIEW B-B A2-2



SECTION D-D D6-2



SECTION F-F C6-2
TYPICAL ON 3 PL

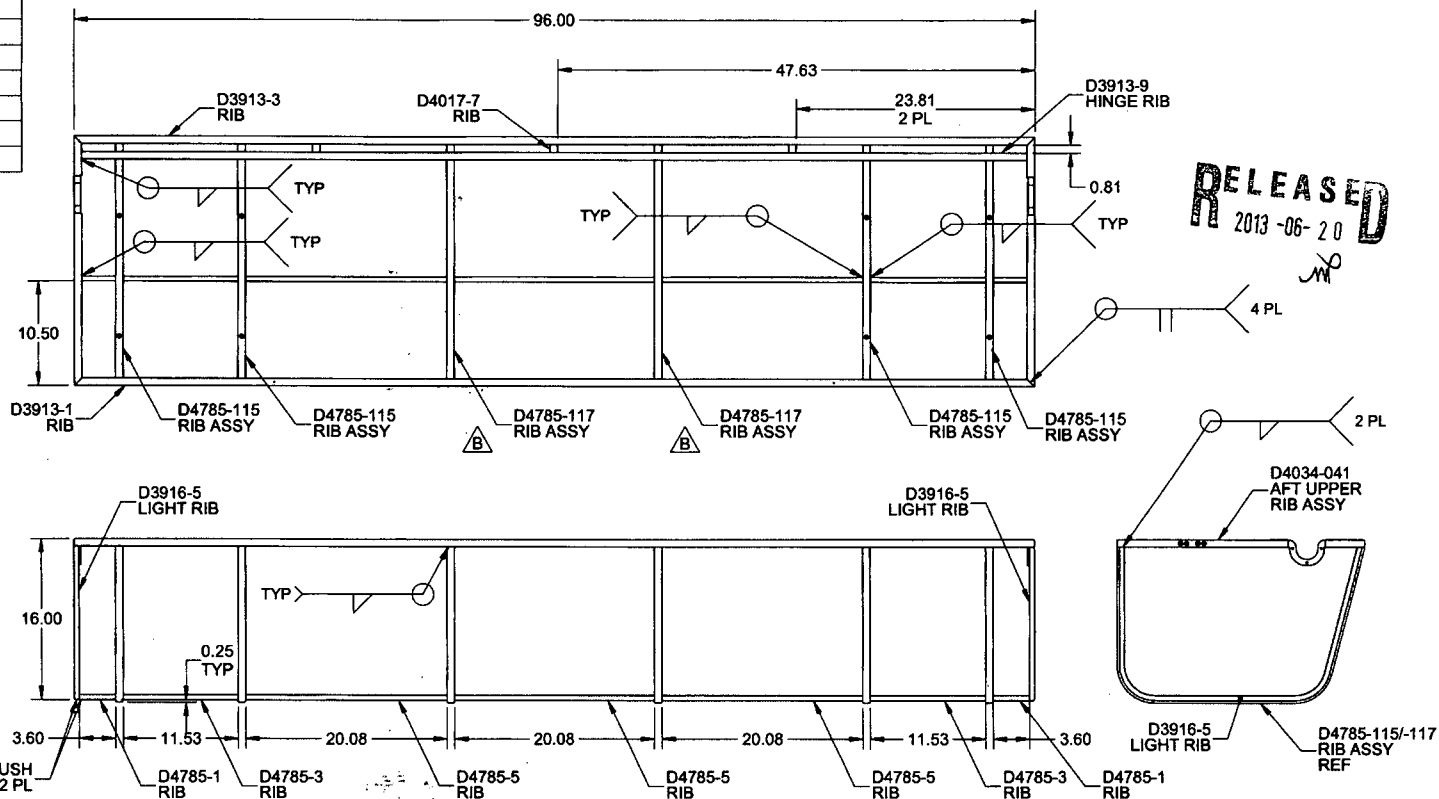


DETAIL E D2-3

RELEASED
2013-06-20

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	D	D4785	SHEET 3 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

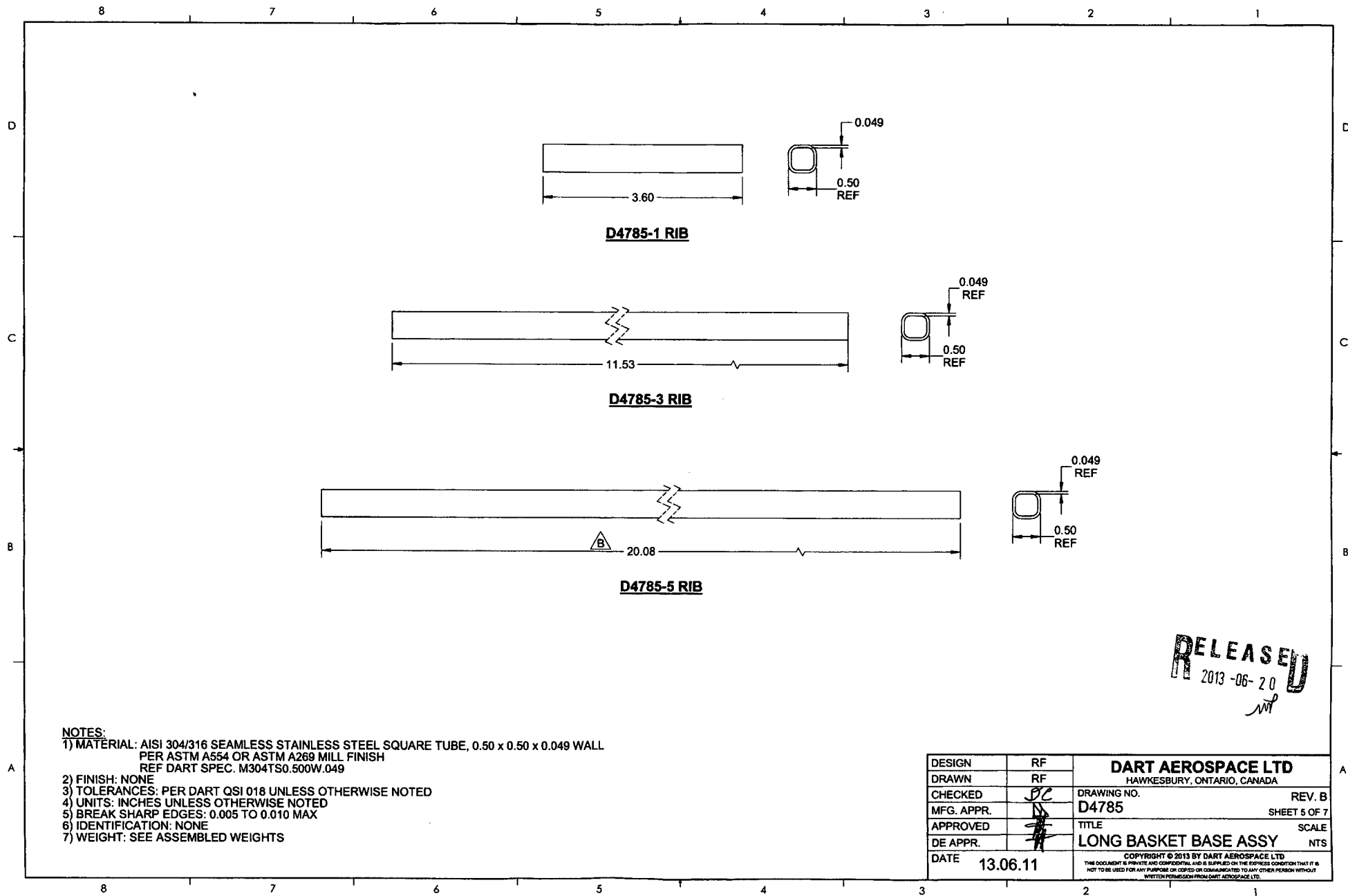
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB



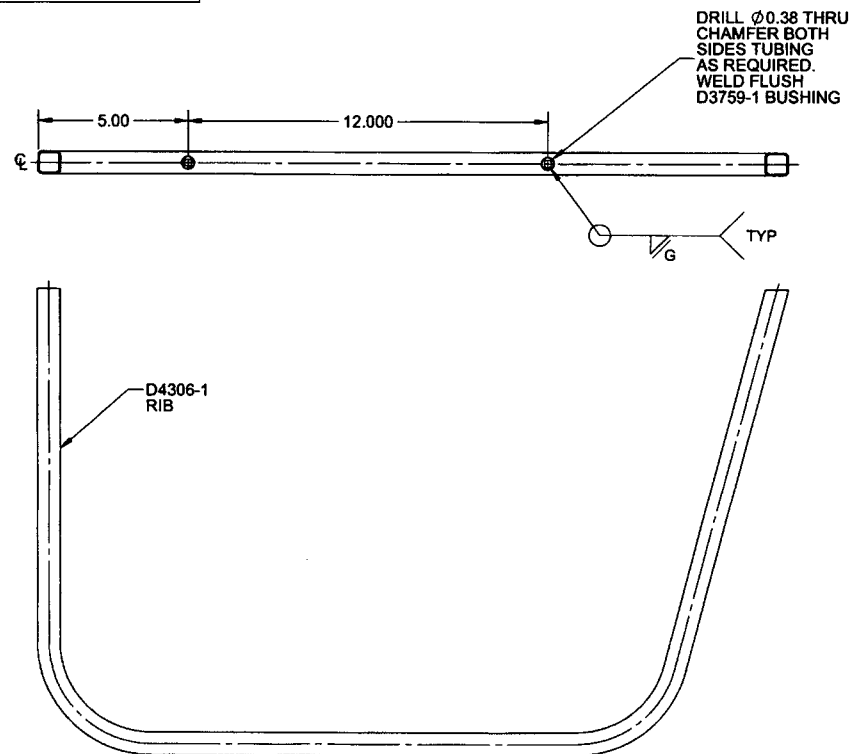
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 28.65 lbs
 - 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4785	SHEET 4 OF 7
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

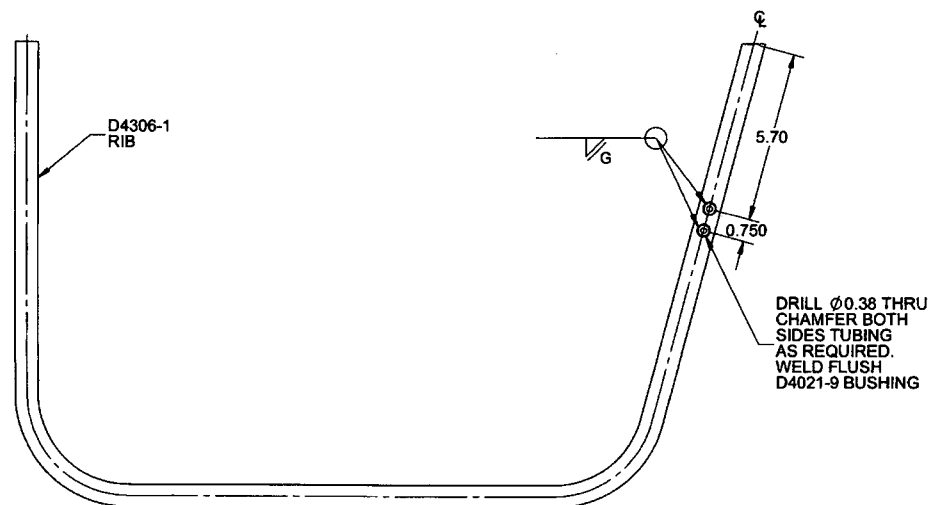
RELEASED
2013-06-20
IND

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	NS	D4785	SHEET 6 OF 7
APPROVED	NS	TITLE	SCALE
DE APPR.	NS	LONG BASKET BASE ASSY	
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

RELEASED
2013-06-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4785	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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